an open-end drill jig. Figs. 39 and 40 show types which are quite similar, but there are many cases where one type can be used to advantage and not the other. For instance, the clamp, Fig. 39, is intended for box jigs, but the type shown in Fig. 40 could not be used for such a jig, because the latter is altogether too slow. However, its advantages over Fig. 39, in case

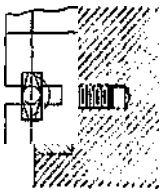

Fig. 36. Jig Cover Locked by

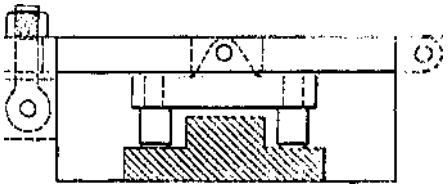

Fig. 37. Jig Cover with Two-point Self-adjusting Clamp

it is desired to have an open-end jig, are apparent. The relation of the first cost of a jig to the quantity of work to be done is a factor which sometimes makes a jig which is not perfect, from a purely mechanical standpoint, more desirable than one which represents better design, but greatly increased cost,

The ordinary jack-screw is employed quite commonly as a clamping device in drill jigs, but the objection to its use is that,